

Work Order ID 60789

July 22, 2010 1:32:08 PM



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Item ID:	D212-725-6-011	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Placard					
Start Date:	7/22/10	Start Qty:	10.00	Cust Item ID:		
Required Date:	7/26/10	Req'd Qty:	10.00	Customer:		

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D212-725-6	Rev C

100		0.00							MAY NOT PULLED
	Waterjet								B10-7-26
FLOW CNC Waterjet	Memo	0.00							(14)
	1-Cut as per Dwg								
	Dwg Rev: <u>E</u>								
	Prog Rev: <u>E</u>								
	2-Deburr if necessary		SB	10/27/29					(14)
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								B10-7-26
Quality Control	Memo	0.00							

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Item ID: D212-725-6-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Placard

Start Date: 7/22/10

Start Qty: 10.00



Cust Item ID:

Required Date: 7/26/10

Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

5.060103

(H4)

130



Purchasing

Purchasing

Memo

Issue P/O:

12389

Send blanks to Turner for laser etching

Manufacture as per Dwg D212-725-6

Supplier: TURNER

Certificate of conformity is required

0.00

0.00

CZ

10/8/11

14

140



Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

Receive and Inspect for transit damage
Ensure C of C included with shipment

0.00

CZ

10/8/23

(14)

P.T.O.

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Item ID: D212-725-6-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Placard

Start Date: 7/22/10

Start Qty: 10.00



Cust Item ID:

Required Date: 7/26/10

Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

SEE ATTACHED w/o.

160

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

*Harvey et.
Cagle
Captains
Calgary.*CZ 10/8/23 14

P.T.O

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/24CZ 10/8/23

Picklist Print

Page 1

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Work Order ID: 60789

Parent Item: D212-725-6-011

Parent Item Name: Placard





Start Date: 7/22/10

Required Date: 7/26/10

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue DD 10.03.31 verified by:EC IPP Rev:B
as per dwg revC DD 10.04.07 verified by:JLM IPP Rev:C 10.07.22
blanks now cut on wj DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D212-725-6-011P 		Purchased	No			140	Each	0.0000	1	10			CL 10/8/23
Placard M304S22GA 		Purchased	No			100	sf	30.7896	0.07	0.7			N/A
304/316 .032 Sheet													1. B 10-7-26
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				MAT20		30.7896							
				109023		30.7896							
				109057									

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Item ID: D212-725-6-011

Accept



Setup: Start



Revision ID:

Item Name: Placard

Stop



Start Date: 7/22/10

Start Qty: 10.00



Cust Item ID:

Required Date: 7/26/10

Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run: Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

5.065103

HC4

Quality Control

130

Purchasing

0.00



Purchasing

Memo

0.00

Issue P/O: 12389
Send blanks to Turner for laser etching
Manufacture as per Dwg D212-725-6
Supplier: TURNER
Certificate of conformity is required

CZ 10/8/11 17

140

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Receive and Inspect for transit damage
Insure C of C included with shipment

q/s

AUG 23 2010

CZ 10/8/23

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Item ID: D212-725-6-011

Accept

Revision ID:

Item Name: Placard

Setup: Start

Stop

Start Date: 7/22/10 Start Qty: 10.00

Required Date: 7/26/10 Req'd Qty: 10.00

Cost Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run: Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC6- Inspect dimensions to drawing

0.00

AUG 23 2010

QC

Memo

0.00

Quality Control

PARTS ARE 3.70 X 2.50 INSTEAD OF
2.80 X 2.00 PER D212-725-6 REV. E
WORKING IS CORRECT SO PARTS ARE
ACCEPTABLE.

AUG 23 2010

160

Identify as per dwg & Stock Location:

0.00

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

DDID-725-6-011

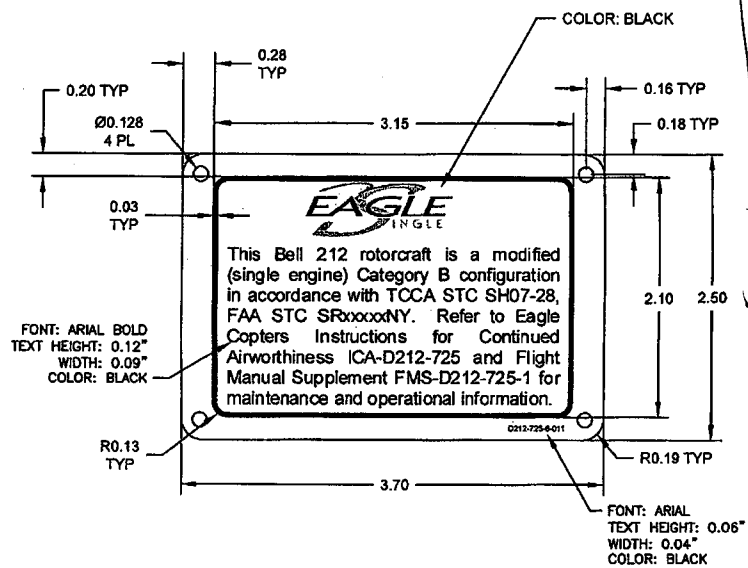
<input checked="" type="checkbox"/>	First Article	<input type="checkbox"/>	Prototype
-------------------------------------	---------------	--------------------------	-----------

Measured by:	RB	Audited by:	S	Prototype Approval:	N/A
Date:	10-7-26	Date:	10/08/23	Date:	N/A

H:\FORMS\Quality Assurance\approved QA\FAI revD

cut blanks / wj?
 sub to
 send blanks to Turner
 for laser etching
 Remy
 DL

104







D212-725-6-011 PLACARD

Waterjet prog.
 - Approved
 - Lxx-xxx-xyy
 - D212-725-6

wlo
 60789

RELEASED
 # 10.03.21

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.030 (22 GAUGE) SHEET, PER AMS-5513/5524 REF. DART SPEC. M304S22GA
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: LASER ETCHED LOGO, LETTERS & P/N AS SHOWN, 0.005\" MAX. DEPTH
 - 7) WEIGHT: N/A

DESIGN		DS		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		RF			
CHECKED				DRAWING NO. REV. C	
MFG. APPR.				D212-725-6 SHEET 6 OF 6	
APPROVED				TITLE SCALE	
DE APPR.				PLACARDS NTS	
DATE		09.12.01			
COPYRIGHT © 2006 BY DART AEROSPACE LTD					
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**Turner Signs (2009) Ltd.**

#4, 4451 58 Avenue S.E.
Calgary, Alberta T2C 1Y3

INVOICE

Invoice No.: 1037
Date: 20/08/2010
Ship Date:
Page: 1

Sold to: Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

Ship to: Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

P.O.: PO12389 Per: Chantal Lavoie

Quantity	Description	Unit Price	Amount
1	New Design Setup Fee	30.00	30.00
14	D212-725-5-011 Placard <i>CL1018124</i>	17.00	238.00
	G - G.S.T. @ 5%		
	G.S.T.		13.40
Terms: Net 30 Days Interest will be charged at 2% per month on any overdue amounts over 30 days. All signs & materials remain the property of Turner Signs (2009) Ltd. until paid in full. GST#: 852269869 RT0001		Total Amount	281.40